

Date: Thursday, 18/12/2008 12:51:31 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DOUBLER
<b>Job Number</b> :	44165		
<b>Estimate Number</b> :	13549		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32341
<b>This Issue</b> :	18/12/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3234 REV B
<b>First Issue</b> :	18/12/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	43629	<b>Drawing Revision</b> :	B
		<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	05/01/2009
<b>Checked &amp; Approved By</b> :	JUD 08-12-19	<b>Qty:</b>	10 Um: Each
<b>Comment</b> :	Est Rev:A New Issue 08-08-14 JLM Verified By:EC Est Rev:B 08-12-18 as per ECN08-582 DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.6080 sf(s)/Unit Total : 6.0795 sf(s)

2024-T3 .050 sheet

BATCH: 107711

HB 9-1-12

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3234

Dwg Rev: B

Prog Rev: B

HB 9-1-12

(10)

2-Deburr if necessary

HB 9-1-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 9-1-12

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/01/12 (X10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

09/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 18/12/2008 12:51:31 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 44165

Part Number: D32341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14 (X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 287

9/1/15

10x

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16 JH

Job Completion



MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44165
Description: <u>DOUBLE</u>		<b>Part Number:</b> D3234-1
Inspection Dwg: <u>D3234-1</u> Rev: <u>B</u>		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.099	✓			
.300	± .010	.301	✓			
.250	± .010	.254	✓			
2.270	± .010	2.270	✓			
2.841	± .010	2.841	✓			
2.627	± .010	2.627	✓			
5.993	± .010	5.995	✓			
7.108	± .010	7.110	✓			
8.228	± .010	8.230	✓			
10.463	± .010	10.466	✓			
10.77	± .030	10.772	✓			
2.25	± .030	2.251	✓			
13.333	± .010	13.333	✓			
15.365	± .010	15.365	✓			
15.665	± .010	15.665	✓			
2.910	± .010	2.912	✓			
3.266	± .010	3.265	✓			
3.495	± .010	3.493	✓			
3.658	± .010	3.656	✓			
<del>5.228</del>	± .010	<del>5.228</del>				
.050	± .010	1049	✓			

<b>Measured by:</b> <u>IB</u>
<b>Date:</b> <u>9-1-12</u>

<b>Audited by:</b> <u>S</u>
<b>Date:</b> <u>9/6/12</u>

<b>Prototype Approval:</b> <u>1</u>
<b>Date:</b> <u>9</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8

7

6

5

4

3

2

1

D

D

C

C

B

**D3234-1 DOUBLER****D3234-3 DOUBLER****D3234-5 SPACER**

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 14165

RELEASED  
08/12/15

**NOTES:**

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
REF DART SPEC M5052H32S.050

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: -1: 0.30 lbs  
-3: 0.15 lbs  
-5: 0.01 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D3234	SHEET 1 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	DOUBLER	NTS
DATE	08.11.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

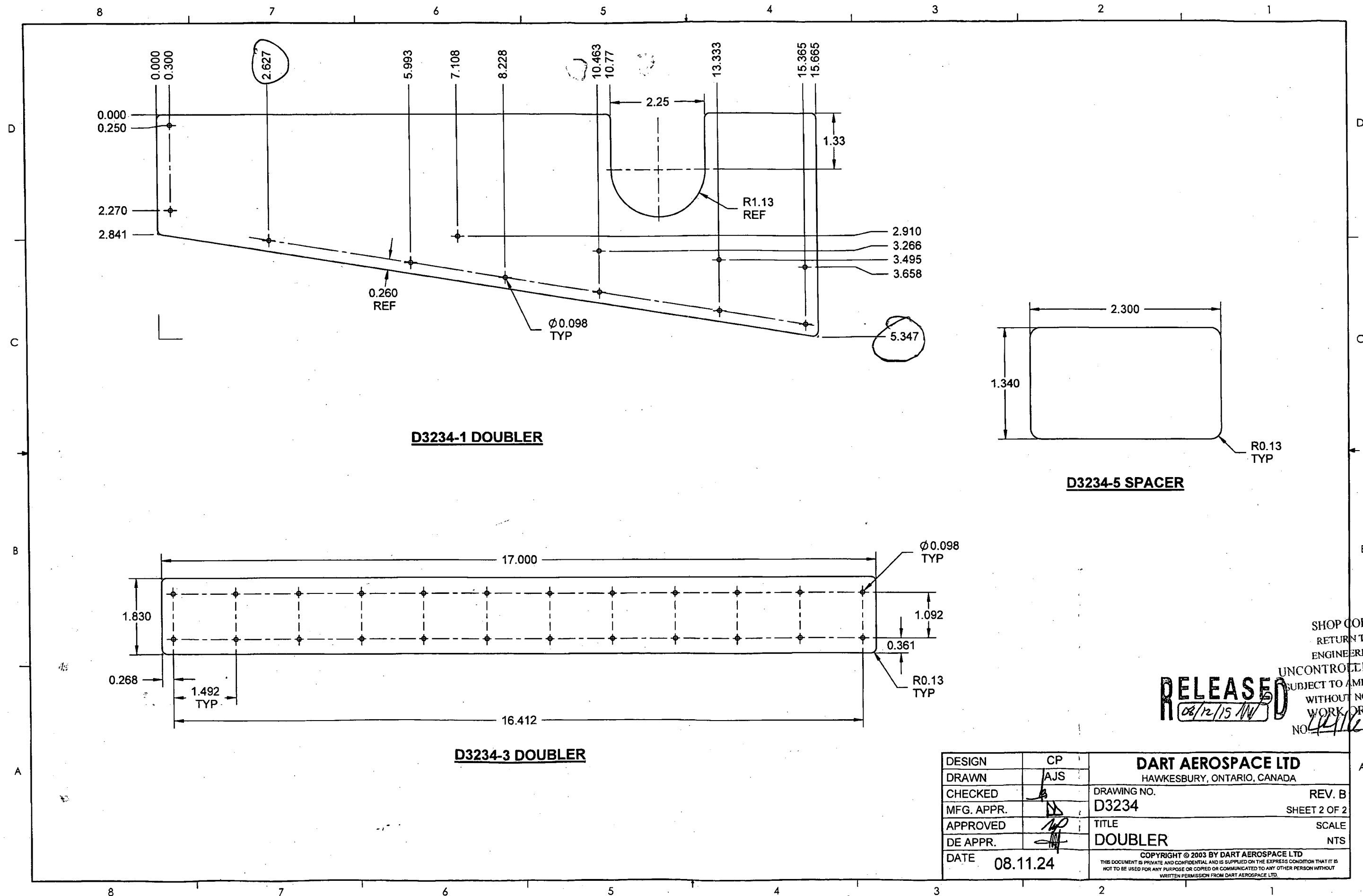
4

3

2

1

A



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WORK ORDER  
NO. 44115

**RELEASED**  
08/12/15

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3234</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLER</b>	NTS
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